



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3901-043
Job Sheet 204109



SAD
19/12/19

Part No: D3901-043

Job Qty: 12 pcs

POSITIVE RECALL

Part Name: Wearbar Weldment



EFFECTIVE _____ AUTH _____

Part Weight: 0 lbs

Status: New

RELEASED _____ DATE _____
Priority: Medium

Job Created: 12/3/19

Job Tracking No:

Due Date: 1/7/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 19-902 DWG D3901 REV.G IPP REV:A 16.06.17 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	12 pcs	1/7/20	1/7/20	0.00	2.40	Large Fab - 1		A
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Automated Welding - B4B	12 pcs	1/7/20	1/7/20	0.50	6.00	Automated Welding - 1 - B4B		WJ
120	QC 10	12 pcs	1/7/20	1/7/20	0.00	0.00	QC 10 - 10		A
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		

ART

OSPACE

No: S255184



001 - 043

04109

Batch: S255184

EV.G

Dart Aerospace Ltd.

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Hawkesbury, ON K64 1K7

CANADA

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Email: sales@dartaero.com

www.dartaerospace.com

Various STC's

Date: 02/12/20

Plex 12/3/19 8:14 AM Dart.lajeunesse.mar



Container No: S255184



Part: D3901 - 043

Job No: 204109

Serial No/Batch: S255184

Revision: REV.G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/12/20

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				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	AL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140	Packaging 3-1 - Stock - B4B	12 pcs	1/7/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
150	QC 21 - SA	12 pcs	1/7/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - 1- CUT BAR AS PER DWG (@ 67.02) 2- GRIND CHAMFERS 3- DEBURR					
Descriptions: 110 - BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) BATCH; M129101					
120 - (QC10- Inspect visual per QSI004- ground welds)					
130 - (QC5- Inspect part completeness to step on W/O)					
140 - (Identify as per dwg & Stock Location: W40023					
150 - (QC21- Final Inspection - Work Order Release)					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304B0.250x0.500	304 Bar .250 X .500	69 ft (5.75 ea)	100-Large Fab - Welded Assy-1	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.250x0.500	69	517	0
Part Specifications				
Specifications could not be found.				

Plex 12/3/19 8:14 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



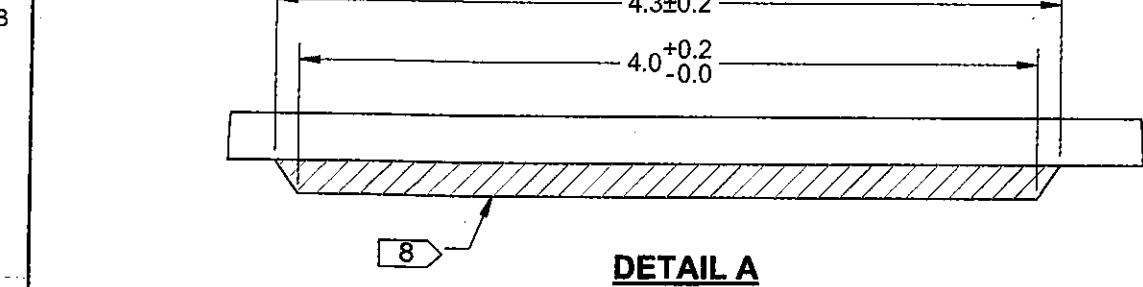
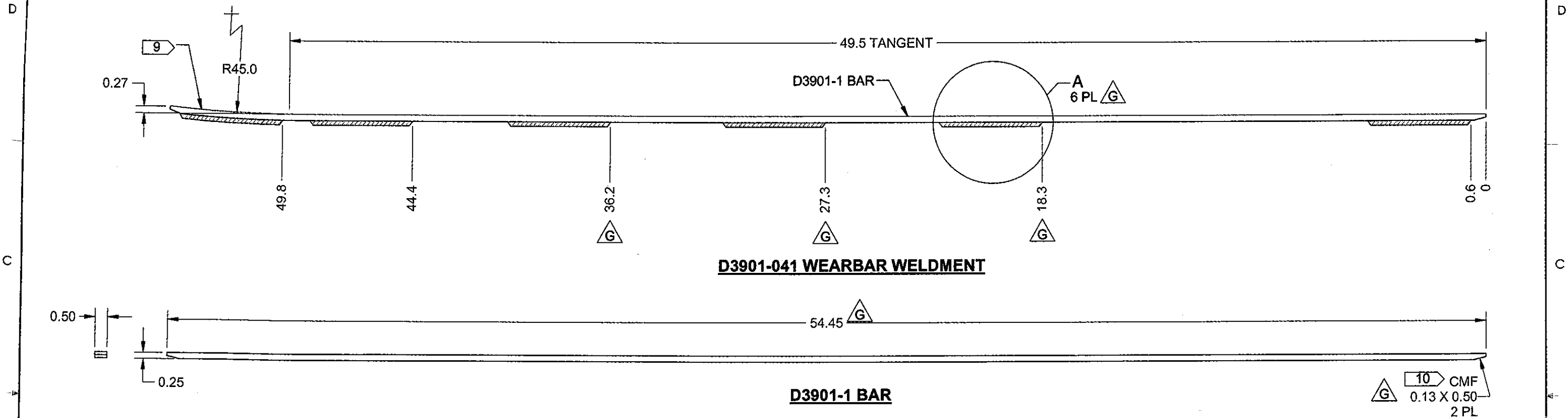
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date :	Sequence #:	QTY Affected :		MRB (QSI042)				
Description Work Order Deviation			Disposition					
						Completed By		
						Lead hand / Supervisor		
			QC / QA Coordinator					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
Other/Details:								

QTY -041	P/N	DESCRIPTION
X	D3901-041	WEARBAR WELDMENT
1	D3901-1	BAR
A/R	8259 \ 2059B	HARD SURFACING

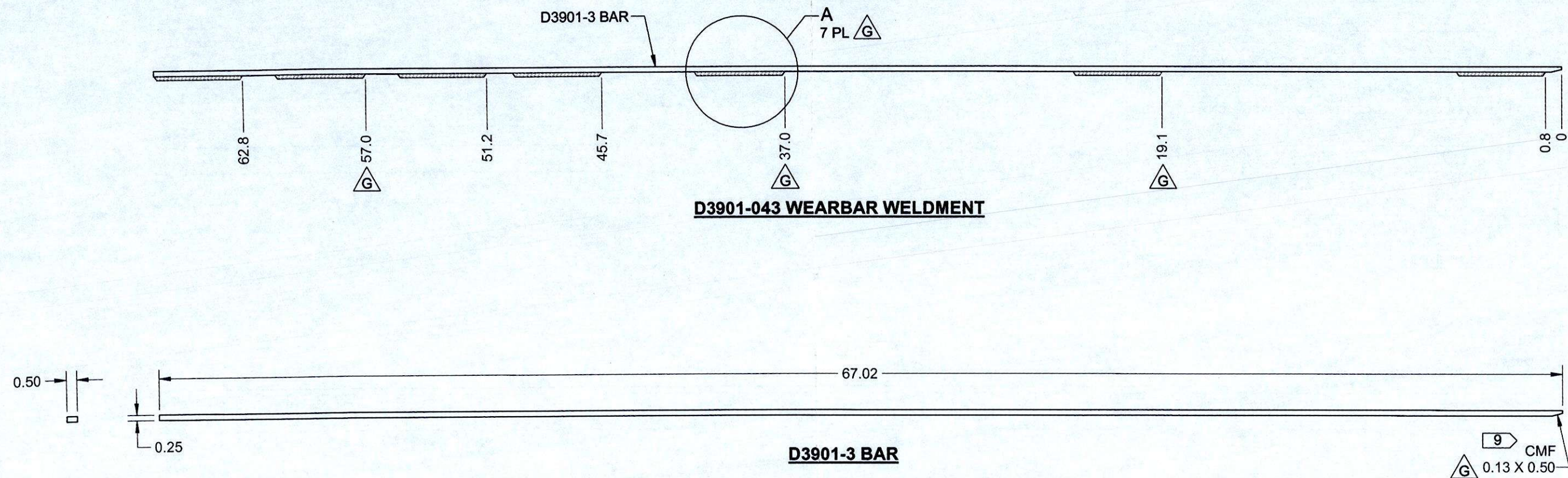


- NOTES:
- 1) MATERIAL: MAKE D3901-1 FROM AISI 304/316 SS BAR PER ASTM A276 OR ASTM A240 REF DART SPEC M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3901-041 = 2.58 lbs
 - 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING)
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) FORM D3901-041 TO FIT WEARPLATE ON FINAL ASSEMBLY
 - 10) GRIND CHAMFER 0.13 X 0.50

G	REDRAWN TO CURRENT STANDARDS. REVISE HARD SURFACING POSITIONS/QTY FOR BETTER WEAR RESISTANCE REF CAR19-319. CHANGE LENGTH OF -1 TO MATCH WEARPLATE. ADDED -047/-7	ZF	19.08.11
F	SEE D3901-1F/-3/-5F GROOVES REMOVED SEE REV E FOR FURTHER DETAILS. ADDED D3901-041/-043/-045. 1B7 ADDED DETAIL A; 3A7 ADDED DETAIL C; 4B4 ADDED DETAIL D; 5B5 ADDED DETAIL E 6B4 ADDED DETAIL F. WELDING SLOTS REMOVED. NOTE 8 RE-WRITTEN FOR NEW PROCESS. 4D4 DIM WAS 54.2. 5D4 DIM WAS 66.87.	AJS	16.01.04
E	CHANGE LOCATION OF END POCKETS ON -1/-3/-5 (ZN B1-2, D8-2, B7-3, B2-3, D1-4, D7-4).	DC	12.08.23
D	CHANGE LOCATION OF END POCKETS ON -1/-3/-5 (ZN D1-2, D8-2, B7-3, B2-3, D1-4, D8-4). SPLIT POCKETS INTO TWO SEPARATE POCKETS (ZN A2-2). ADD POCKET TO -1 (ZN D6-2).	DC	12.08.21
C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901-1F/-5F FLAT PATTERN	RF	12.01.24
B	REMOVE Ø0.188 HOLES FROM D3901-1/-3/-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. G
MFG. APPR.	DD	D3901	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	BAR	NTS
DATE	19.06.11	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED

QTY -043	P/N	DESCRIPTION
X	D3901-043	WEARBAR WELDMENT
1	D3901-3	BAR
A/R	8259 \ 2059B	HARD SURFACING



NOTES:

1) MATERIAL: MAKE D3901-3 FROM AISI 304/316 SS BAR
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3901-043 = 3.13 lbs

8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING)

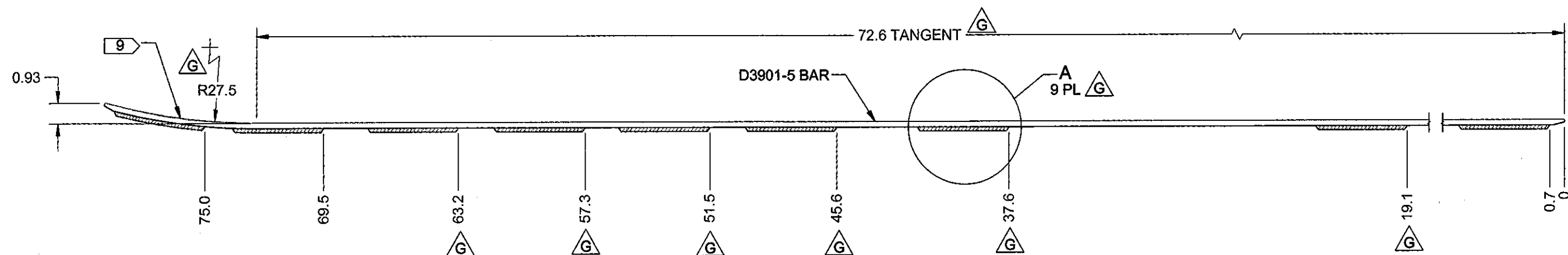
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

9) GRIND CHAMFER 0.13 X 0.50

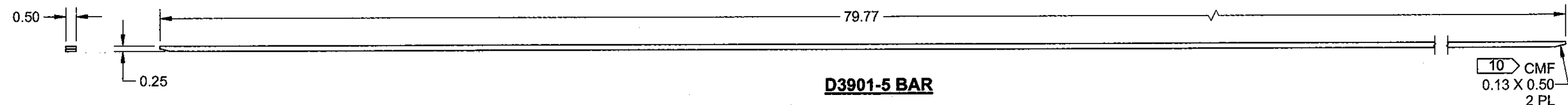
RELEASED

DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
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MFG. APPR.	DD		SHEET 2 OF 4
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DE APPR.	DS		
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QTY -045	P/N	DESCRIPTION
X	D3901-045	WEARBAR WELDMENT
1	D3901-5	BAR
A/R	8259 \ 2059B	HARD SURFACING



D3901-045 WEARBAR WELDMENT



D3901-5 BAR

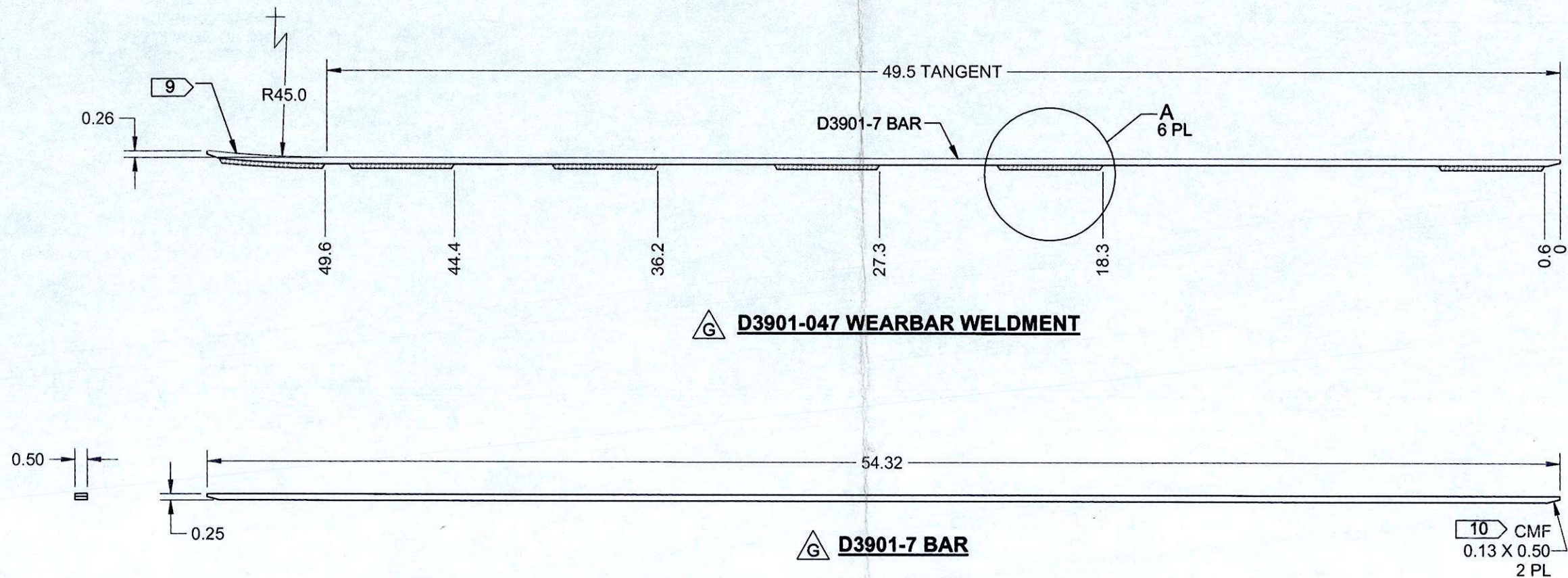
NOTES:

- 1) MATERIAL: MAKE D3901-5 FROM AISI 304/316 SS BAR
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3901-045 = 3.80 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING)
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) FORM D3901-045 TO FIT WEARPLATE ON FINAL ASSEMBLY
- 10) GRIND CHAMFER 0.13 X 0.50

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CHECKED	MW	DRAWING NO.	REV. G
MFG. APPR.	DD	D3901	SHEET 3 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	BAR	NTS
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QTY -047	P/N	DESCRIPTION
X	D3901-047	WEARBAR WELDMENT
1	D3901-7	BAR
A/R	8259 \ 2059B	HARD SURFACING



NOTES:

- 1) MATERIAL: MAKE D3901-7 FROM AISI 304/316 SS BAR
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3901-047 = 2.57 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING)
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) FORM D3901-047 TO FIT WEARPLATE ON FINAL ASSEMBLY
- 10) GRIND CHAMFER 0.13 X 0.50

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	CHECKED	MW	DRAWING NO.	REV. G
	MFG. APPR.	DD	D3901	SHEET 4 OF 4
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	BAR	NTS
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